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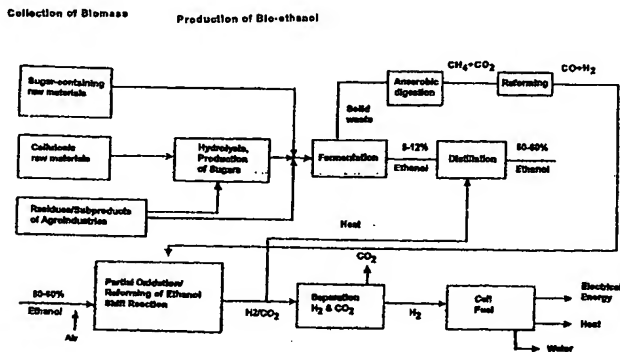
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INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(54) Title: PROCESS FOR THE PRODUCTION OF HYDROGEN AND ELECTRICAL ENERGY FROM REFORMING OF BIO-ETHANOL.



A process for the production of hydrogen and electrical energy, with zero emission of pollutants, from ethanol which is produced from biomass, which is characterized by the partial oxidation/reforming of ethanol with water for hydrogen production which is subsequently fed to a fuel cell for production of electrical energy, more specifically where an aqueous solution of ethanol originating from fermentation of biomass is separated by distillation or any other technique so as to obtain approx. 40–70 % by weight of ethanol, preferably 50–60 %, this mixture, mixed with a suitable quantity of air in such a way so as the ratio of moles oxygen per mole ethanol to be between zero and 0.5, is fed to a reactor in which the reactions of partial oxidation and reforming of ethanol are taking place over a suitable catalyst, where in the same or a different reactor the shift reaction is taking place and, if necessary, the reaction of combustion of CO or its conversion to CH₄, where the gaseous mixture from the exit of the reactors which contain hydrogen in mixture with carbon dioxide, nitrogen, methane or other gases in small quantities, is separated to the extent which is desirable for any kind of application.

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**PROCESS FOR THE PRODUCTION OF HYDROGEN AND ELECTRICAL
ENERGY FROM REFORMING OF BIO-ETHANOL**

5

The present invention refers to a process for the production of hydrogen and electrical energy from reforming of bio-ethanol, with the use of fuel cells and zero emission of pollutants. Ethanol is produced from biomass which contains
10 sugar and/or cellulosic components, originating from any source. Aqueous solution of ethanol (40-70% by weight) is mixed with air (0-0,5 mol oxygen per mol ethanol) and is fed to a reactor which contains suitable catalyst so as for the reactions of partial oxidation and reforming of ethanol to take
15 place. In the same or a different reactor the shift reaction for the consumption of carbon monoxide and further production of hydrogen is taking place.

The gaseous mixture which is produced in this manner is rich
20 in hydrogen which can be separated and used in different applications. Alternatively, the gaseous mixture is fed to a fuel cell, preferably of the phosphoric acid or proton exchange membrane or solid polymer, in which electrical energy and heat are produced.

25

No emissions harmful to the environment are produced in any of the stages of the above process.

Technical field

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The use of biomass as a renewable energy source has been investigated and proposed for many years [1]. Three different means of use of biomass as energy source have been applied internationally: Combustion, pyrolysis for the production of
35 gaseous and liquid fuels, and fermentation for the production of ethanol. Sources of biomass can be plants which have

certain specific characteristics and which are grown for this purpose, or waste materials from cultivation of edible products or from agroindustries or from forestry. Studies which have been conducted in recent years show that there
5 are significant quantities and sources of biomass which can be utilized for the production of energy.

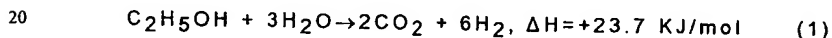
The production of ethanol from biomass which is often referred to in the bibliography as "bio-ethanol", is known and
10 is practiced in large scale, mostly in North and South America and in Europe [2]. The processes for the production of ethanol can be classified in two large categories: Those which utilize sugar-containing raw materials - products of energetic cultivations (for example sweet sorghum) and those
15 which utilize cellulosic raw materials originating from energetic cultivations (sorghum, cane, solid residue of sweet sorghum, etc) as well as from residues of agroindustries. In the first case sugars are directly fermented for the productions of ethanol while in the second case the
20 hydrolysis step or other processes are preceeded for the production of sugars which are then converted to ethanol via fermentation [1,2].

Although the technology of biomass fermentation for the
25 production of ethanol is mature, it has not been applied in large scale, at least in Europe, for economic reasons. A large fraction of the cost of bio-ethanol is the cost of separation of the aqueous solution which derives from fermentation and which contains approximately 8 to 12% ethanol. In order to
30 use ethanol as a fuel in internal combustion engines the required purity exceeds 99%. Because ethanol and water form an azeotropic solution when the ethanol content is approximately 95%, further purification requires energy-consuming techniques, the application of which increases
35 significantly the cost of bio-ethanol.

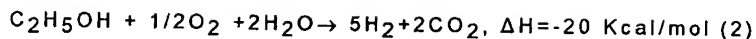
Brief description of the invention

Purpose of the present invention is to utilize ethanol which is produced from biomass for the production of energy without the requirement of its separation from water to a large degree. With the new method which is presented, the cost of ethanol production is reduced significantly while, simultaneously, the thermodynamic efficiency of its use is increased significantly (with the application of fuel cells) and the gaseous pollutants which are produced during its burning (for example in internal combustion engines) are eliminated.

According to the present invention, a mixture of ethanol, oxygen and water react and produce hydrogen and carbon dioxide, and the hydrogen is fed to a fuel cell which produces electrical energy from the electrochemical oxidation of hydrogen to water. The reforming of ethanol with water which is described by the reaction:



has been little investigated, in contrast to the reforming of methanol. It has been reported that reforming of ethanol over a copper catalyst or a Pd/ZnO produces acetic acid, acetaldehyde, H₂ and heavier oxygen-containing products [3]. Acetaldehyde is also produced when the reaction is taking place on Ni and Pt catalyst supported on MgO[4]. Complete reforming of ethanol on Ni catalyst has been reported, which, however, deactivates rapidly, probably due to carbon deposition [5]. The reaction of reforming of ethanol with water (Reaction 1) is endothermic and consequently supply of heat to the reactor is required. The simplest way to achieve this is the co-feeding of oxygen (air) together with the ethanol-water mixture over a suitable catalyst so as a small fraction of ethanol to be oxidized towards CO₂ and H₂O, producing the required heat for the reforming reactions:



As far as we know, no study has appeared in the literature
5 referring to the partial oxidation/reforming of ethanol.

According to the invention which is presented the hydrogen
which is produced from the partial oxidation/reforming of
ethanol, is fed to a fuel cell for the production of electrical
10 energy. The advantages of fuel cells are the zero emission of
pollutants since the only product of combustion of hydrogen
is water and the improved thermodynamic efficiency in
comparison with internal combustion engines.

15 Fuel cells are an innovation which finds applications in the
production of electrical energy without the emission of
pollutants, consuming hydrogen as fuel which is oxidized
electrochemically with oxygen, with simultaneous production
of electrical energy [6]. The efficiency of fuel cells is
20 approaching 70% of the heat which corresponds to the
combustion of hydrogen, i.e. it is twice the efficiency of
thermal engines which is subjected to the thermodynamic
constraints of the Carnot type. There are five types of fuel
cells which differ in the type of electrolyte and in the
25 temperature of operation. 1) Phosphoric Acid which is the
most commercially advanced type and operate at
temperatures around 200°C. They produce electrical energy
with efficiency from 40 to 80% [7]. 2) Proton exchange
membranes or solid polymers which operate at low
30 temperatures, approximately 100°C, and offer large power
density with quick response to power demands [8]. 3) Solid
Oxide Fuel Cells which can be utilized in applications in
which large power is required and operate at about 1000°C
[9]. 4) Molten Carbonate Salts, whose electrolyte consists of
35 molten carbonate salts of Li and K, the fuel is hydrogen and
CO and the oxidizing mixture consists of oxygen and CO₂.

They operate at temperatures of 600°C with a large efficiency of fuel over power production [9]. 5) Alkalines which were used in space applications and produced power with an efficiency of approximately 70% operating at temperatures 60-150°C.

Description of Drawings

Figure 1: Schematic diagram of the process of hydrogen and electrical energy production from biomass with a zero pollutant emission. The first part of the process concerns the production of ethanol from biomass and the separation of a fraction of water so as to obtain a 50-60% by weight ethanol concentration. The second part concerns the reactions of partial oxidation/reforming and shift of ethanol for the production of hydrogen and its separation from CO₂ if necessary. The third part concerns the production of electric energy using fuel cells.

Figure 2: Schematic diagram of a reactor suitable for ethanol partial oxidation/reforming reactions. The reactor consists of a bundle of ceramic or metallic tubes. In the internal surface of the tubes the partial oxidation catalyst is deposited in the form of a thin film while in the external surface the reforming catalyst is deposited. The reactor gives a high thermal stability and safe operation over high temperatures.

Description of proposed embodiment

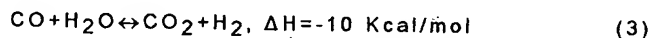
The process of hydrogen and electrical energy production which is invented is presented diagrammatically in Figure 1. The first part of the process concerns the production of

ethanol via fermentation of sugars which are obtained directly from biomass or which are produced from cellulosic raw materials of biomass or from any type of suitable biomass which is a byproduct or waste product of industries involved in processing of agricultural or forestry products. The process of fermentation of sugars and production of ethanols is known and is applied industrially in large scale [1,2]. The ethanol which is produced by fermentation is contained in aqueous solution in concentrations of approximately 8-12%. The aqueous solution is then distilled so as to increase the ethanol content to the level of 50-60% by weight. The energy which is required for the distillation is obtained from the partial oxidation/reforming reactor (see Figure 1). The process of distillation is also well known and is applied in large scale in chemical and petrochemical industries.

The aqueous solution which contains ethanol is subsequently fed to the partial oxidation/reforming reactor into which air is simultaneously fed with such a flow rate so that the quantities of ethanol and oxygen to be in stoichiometric proportion according to Reaction 2. Of course, the quantities of oxygen (air) which are fed to the reactor may be smaller or larger than the stoichiometric proportion, depending on the derived characteristics of the reaction, mainly the heat of reaction. For the reactions of partial oxidation/reforming of ethanol a suitable catalyst is required which must be sufficiently active and stable in time of use and especially selective for hydrogen production. Such a catalyst may contain metals of Group VIII of the Periodic Table or metals/metal oxides of the Transition Metals or combination of the above, either by themselves or supported onto different carriers which are used for this purpose. A good catalyst for the partial oxidation/reforming of ethanol is a catalyst which contains Ni dispersed onto a Lanthanum oxide carrier, which is described in a Patent Application [10]. Another good catalyst consists of metals of Group VIII of the

Periodic Table dispersed on a carrier of Titanium Oxide doped with cations of Tungsten (W) [11].

High selectivity towards CO_2 in the reforming reaction is desirable since at least some types of fuel cells do not operate efficiently when the feed contains CO at concentration higher than 20-100 ppm, due to poisoning of the platinum electrode. Because the concentration of CO at the exit of the partial oxidation/reforming reactor will be higher than 100 ppm, processing of the gas in a shift reactor is required in which the following reaction is taking place:



The shift reaction is an equilibrium reaction and the conversion of CO increases with reduced temperature. This reaction has been studied by many researchers and there are various efficient catalysts for it [2]. If at the exit of the shift reactor the concentration of CO is higher than 100 ppm, this must be oxidized in the presence of a suitable catalyst, in another reactor in which a small quantity of oxygen or air is fed. Gold catalysts supported on selected carriers are active in the selective oxidation of CO in the presence of hydrogen at low temperatures [13]. There is also the alternative solution of hydrogenation of CO towards CH_4 , a reaction which is easily conducted over numerous catalysts.

The reaction of partial oxidation/reforming of ethanol can take place in any type of suitable reactor, as for example fixed bed reactor, fluidized bed reactor etc. For reactions of this type whose one part is exothermic (partial oxidation) and the other endothermic (reforming) we have developed a particularly efficient and safe reactor which consists of a bundle of ceramic or metallic tubes of small diameter which are encased in a vessel which is thermally insulated, as presented in Figure 2. In the internal area of the tubes the

partial oxidation catalyst is deposited while in the external area the reforming catalyst is deposited. The two catalysts may be the same or different. The heat which is produced by the oxidation of part of the fuel is transported through the wall in the external area of the tube, where the endothermic reforming reactions are taking place which consume the transported heat. In this way the reactor can operate adiabatically, the temperature distribution along the length of the reactor is controlled to a large extent, the operation of the reactor is safe since no hot zones are developed, the danger of explosion is eliminated, the pressure drop is small and the productivity of the reactor is high due to the optimization of the heat management of the reaction.

As is shown in Figure 2, a large fraction of the length of the tubes does not contain catalysts. This part of the tubes is used as heat exchanger to heat the feed, which is introduced at low temperatures, from the reaction products which are at high temperature. In this manner the total volume of the process is minimized.

The shift reaction can take place in the same or different reactor. In the first case, in the external area of the tubes a catalyst for this reaction is deposited. Alternatively, catalysts in particle or pellet form can be placed in the volume external to the tubes if a larger area is required.

The length of the tubes which contains catalysts in the internal and external surface, the quantity of catalysts on each side, the type or types of catalysts, the total length of the tubes, the space at which the shift reaction is taking place, the diameter of the encasing vessel, and other similar parameters are defined in such a way so as to maximize the productivity of the reactor.

The reaction of partial oxidation/reforming of ethanol, with the stoichiometry described by Equation 2, is exothermic and for every mole of ethanol which reacts approximately 20 kcal of heat are produced. Of course, the exact quantity of heat which is produced can be controlled depending on the quantity of air or oxygen which is fed into the reactor. The heat of this reaction can be used not only for the preheating of the reactants (along with the heat of the products of the reaction) but also in the process of distillation of the aqueous solution of ethanol from the initial concentration of 8 to 12% to the desired concentration of 50 to 60%.

The hydrogen which is produced with the series of reactions which were described above i.e. the partial oxidation/reforming of ethanol, the shift reaction and, if necessary, the reaction of selective oxidation of CO, is fed to a fuel cell in which it is being oxidized electrochemically with oxygen with simultaneous production of electrical energy and heat. The most suitable fuel cells for the present application are those of the phosphoric acid type or the proton exchange membrane or solid polymers. The heat which is produced simultaneously with the electrical energy is generally of low quality because of the low temperatures (100-200°C) and can be used for the heating of greenhouses if the application is taking place in an agricultural area or buildings if the application is taking place near an urban center.

The process for production of hydrogen and electrical energy which is described above and is presented diagrammatically in Figure 1 is a typical such process in which many alterations can take place, depending on specific situations or specific applications, without altering the present invention. The same is true for the catalysts and reactors of the partial oxidation/reforming of ethanol.

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Claims

1. A process for the production of hydrogen and electrical energy, with zero emission of pollutants, from ethanol which is produced from biomass, which is characterized by the partial oxidation/reforming of ethanol with water for hydrogen production which is subsequently fed to a fuel cell for production of electrical energy, more specifically where an aqueous solution of ethanol originating from fermentation of biomass is separated by distillation or any other technique so as to contain approx. 40-70% by weight of ethanol, preferably 50-60%, this mixture, mixed with a suitable quantity of air in such a way so as the ratio of moles oxygen per mole ethanol to be between zero and 0,5, is fed to a reactor in which the reactions of partial oxidation and reforming of ethanol are taking place over a suitable catalyst, where in the same or a different reactor the shift reaction is taking place and, if necessary, the reaction of combustion of CO or its conversion to CH₄, where the gaseous mixture from the exit of the reactors which contain hydrogen in mixture with carbon dioxide, nitrogen, methane or other gases in small quantities, is separated to the extent which is desirable for any kind of application.
2. A process as described in claim 1 according to which the hydrogen is fed as fuel to a fuel cell for the production of electrical energy and heat.
3. A process as described in claim 2 in which the fuel cell is of the phosphoric acid type or proton exchange membrane or solid polymer or of any other suitable type.
4. A process as in claim 1 in which the reactor of partial oxidation/reforming or partial oxidation/reforming/shift is of the fixed bed type, or of any other type or this reactor consists of tubes in the internal wall of which a catalyst is

deposited and in the external wall is deposited the same or other catalyst or more than one catalyst in series.

5. A process as in claim 1 in which the catalyst of partial oxidation/reforming of ethanol contains metal of the Group VIII of the periodic table or metal oxide of the Transition Metals of the Periodic Table, either supported on suitable carrier or not.

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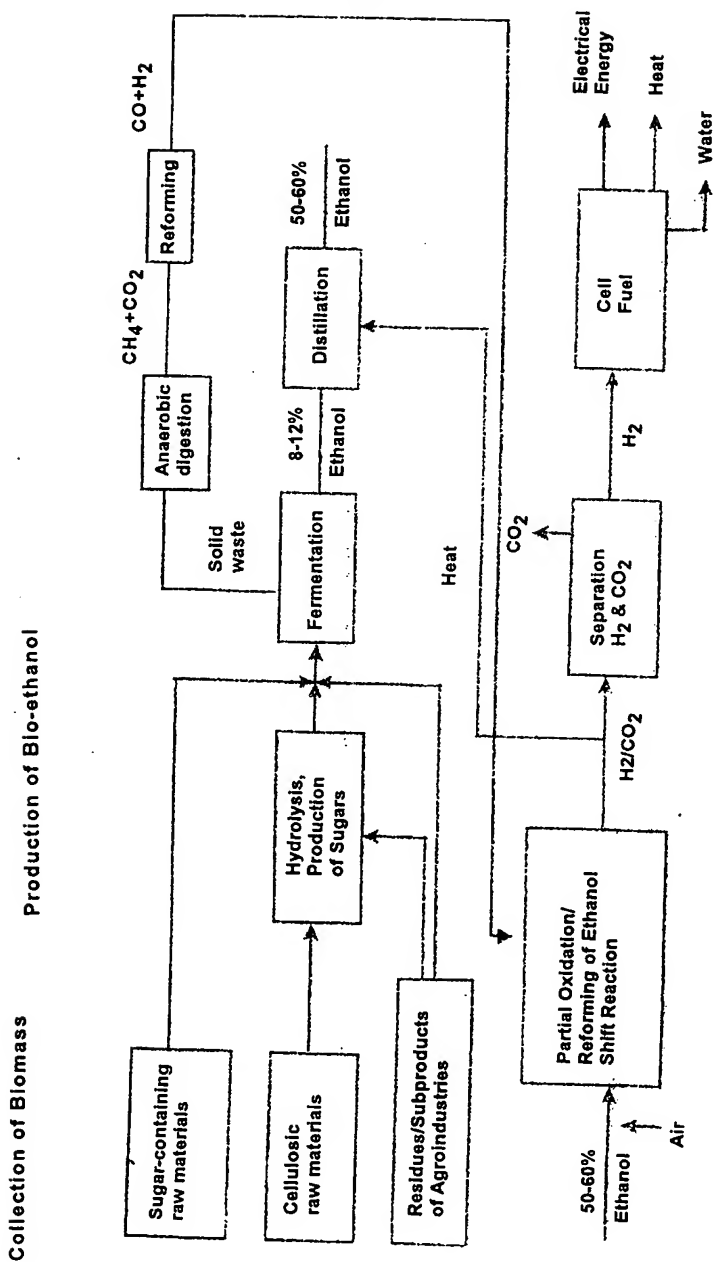


Figure 1

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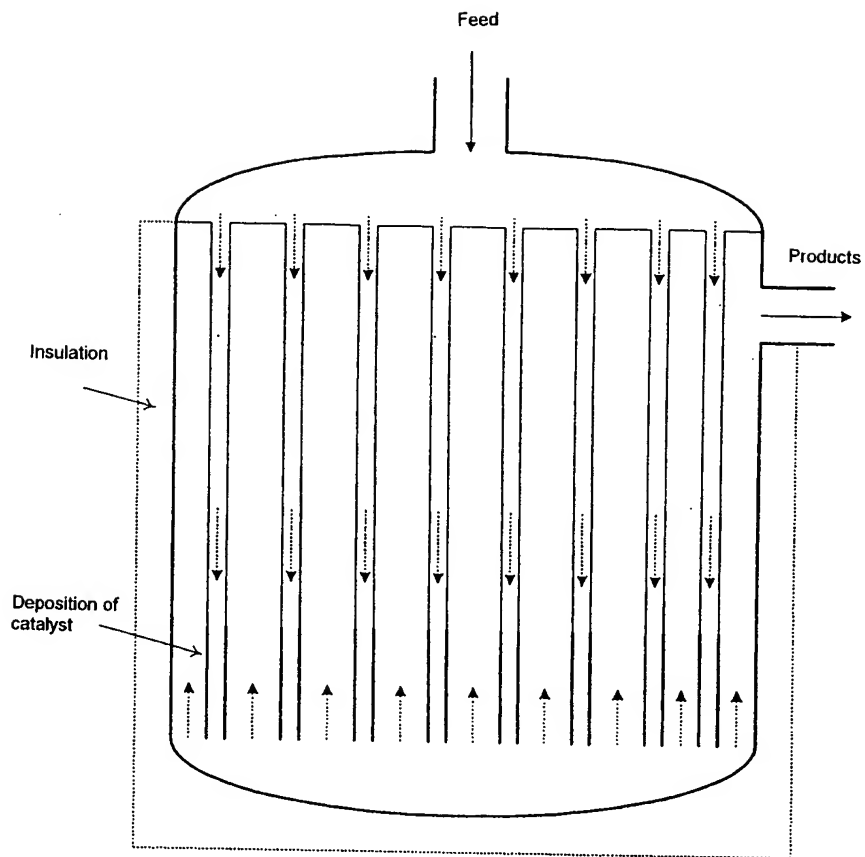


Figure 2

INTERNATIONAL SEARCH REPORT

International Application No
PCT/GR 99/00020

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 C01B3/32 H01M8/06

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 C01B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

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C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	BIRDSELL S A WILLMS' R S ET AL: "PURE HYDROGEN PRODUCTION FROM OCTANE, ETHANOL, METHANOL, AND METHANE REFORMING USING A PALLADIUM MEMBRANE REACTOR" IECEC '97. PROCEEDINGS OF THE 32ND INTERSOCIETY ENERGY CONVERSION ENGINEERING CONFERENCE. ENERGY SYSTEMS, RENEWABLE ENERGY RESOURCES, ENVIRONMENTAL IMPACT AND POLICY IMPACTS ON ENERGY, HONOLULU, HI, JULY 27 - AUG. 1, 1997, vol. 3 & 4, 27 July 1997 (1997-07-27), pages 1942-1946, XP000779068 AND ELECTRONICS ENGINEERS the whole document --- -/--	1

☒ Further documents are listed in the continuation of box C.

☐ Patent family members are listed in annex.

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Date of the actual completion of the international search

20 August 1999

Date of mailing of the international search report

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INTERNATIONAL SEARCH REPORT

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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication where appropriate, of the relevant passages	Relevant to claim No.
X	S. P. KOTHARI ET AL.: "Economics of biomass-derived alcohol application in fuel cells" ENERGY PROGRESS, vol. 2, no. 4, December 1982 (1982-12), pages 187-191, XP002102013 USA the whole document	1
X	DATABASE APILIT 'Online! THE AMERICAN PETROLEUM INSTITUTE, NEW YORK, NY, US document no. 4502054, 1998 F. HAGA ET AL.: "Effect of particle size on steam reforming of ethanol over alumina-supported cobalt catalyst" XP002102015 abstract	1
X	& NIPPON KAGAKU KAISHI, no. 11, November 1997 (1997-11), japan	1
X	DATABASE WPI Section Ch, Week 8813 Derwent Publications Ltd., London, GB; Class E36, AN 88-088358 XP002112855 & JP 63 039626 A (YAMAHA HATSUDOKI KK), 20 February 1988 (1988-02-20) abstract	1
X	R. KUMAR ET AL.: "Fuel processing requirements and techniques for fuel cell propulsion power" ACS 206TH NATIONAL MEETING, vol. 38, no. 4, 1993, pages 1471-1476, XP002102014 USA the whole document	1
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/GR 99/00020

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